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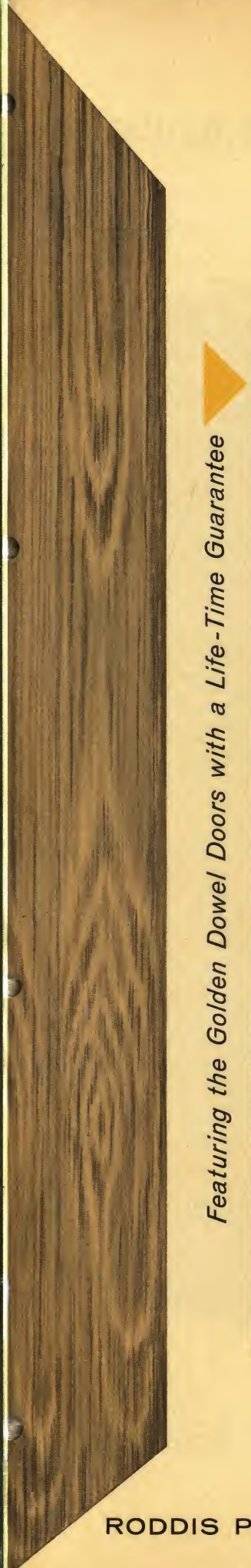
ONE SOURCE for all
your requirements

Roddis
FLUSH
VENEERED
DOORS

A.I.A. FILE NO. 19-E-1



Featuring the Golden Dowel Doors with a Life-Time Guarantee

SOLID CORE
FIRE (B- AND C-LABEL)
HOLLOW CORE
INSTITUTIONAL
PLASTIC FACED
X-RAY
SOUNDPROOF

RODDIS PLYWOOD CORPORATION, MARSHFIELD, WISCONSIN **1960**

Roddis GOLDEN DOWEL, SOLID CORE

The GOLDEN DOWEL solid core door is guaranteed for the life of the installation.

The Roddis Golden Dowel Door is truly an outstanding new development in door technology. The new process of TIME CONDITIONING is employed in its manufacture. This process, developed after extensive research, is another example of Roddis leadership in the door industry.

With this important development, for the first time, it is now possible to obtain staved wood core doors in which you can place your absolute confidence . . . Confidence backed by Roddis manufacturing skill . . . Confidence backed by a Lifetime Guarantee.

ALL Roddis doors are identified by a colored dowel on one edge of the door as stated in each door specification in this catalog. Please be certain to include this dowel information in *your* specifications so that you can be assured that only genuine Roddis doors will be used.

LIFETIME GUARANTEE

The purchaser of Roddis Golden Dowel doors and B-label, one-hour, fire doors is indemnified against loss under this guarantee by an insurance policy issued by one of the largest insurance organizations in the world.

DETAILS OF LIFETIME GUARANTEE

"The Roddis Plywood Corporation guarantees its Golden Dowel doors and B-label, one-hour, fire doors for the life of the installation, to be of good workmanship and material, free from defects, which render them unserviceable or unfit for the use for which they were manufactured, and agrees to pay the rehanging and refinishing costs of a reasonable nature for any door found defective within the meaning of this guarantee. This guarantee applies only if the doors are properly handled, protected and installed. Doors used in exterior locations must be protected at the bottom of the lights and at the bottom of the doors with approved metal flashing. Doors must be painted or varnished on all four edges as well as faces and must be kept in good finish at all times. Structural strength of the doors must not be impaired in the fitting of the door or application of hardware. Serial plate on the hinge side of door must be retained in place on the door for inspection."

FLUSH VENEERED DOORS

FIRE RESISTANT

The fire resistance of Roddis solid core flush veneered doors has been substantiated by independent laboratories. Here, Roddis doors withstood a regular fire test for over 40 minutes. (For information on B-Label, one-hour, fire doors, see pages 6 to 11).

SOUND RESISTANT

Roddis solid core doors have high sound resistance. Roddis also manufactures special soundproof doors designed to reduce noise to a minimum. (See Page 14).

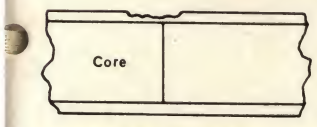
WATERPROOF

Use of phenolic resin glue provides two completely waterproof shields over the entire area of the door. Doors are suitable for both interior and exterior applications.

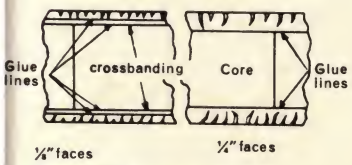
PLASTIC FACES AVAILABLE

Roddis Golden Dowel solid core doors and standard solid core doors are available with 1/16″ high-pressure laminate faces for interior application. Laminates are bonded to 1/7″ veneer crossband with a waterproof adhesive. Plastic fits flush with door rails. Crossband is not visible. Make of laminate and pattern desired may be specified.

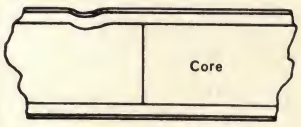
Compare the advantages of Roddis construction over heavy face veneer construction



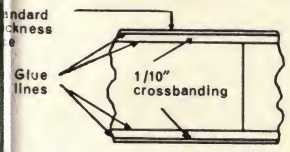
Heavy face veneer construction
Because of grain characteristics of wood, sharp blow is more likely to cause chipping here, rather than dent, requiring replacement of veneer or extensive sanding.



Heavy face veneer construction
Veneers are held at glue line, but excessive thickness makes exposed surface vulnerable to temperature & humidity changes.



Roddis construction
Dents affect face & crossbanding as a unit —can be raised by applying water and hot iron.
If face veneer is gouged out, matching replacement is relatively easy with standard thickness face veneers.



Roddis construction
Waterproof glue line close to surface prevents movement of face veneers caused by climatic action.

Note: In some exterior applications, face veneers up to ¼" in thickness may be used advantageously, depending upon the type of wood and the amount of resistance to wear and weathering that is required. Roddis will be happy to discuss these applications with you.

SPECIFICATIONS — *Golden Dowel Solid Core Doors*

(See page 5 for specifications on Standard Solid Core Doors)

GENERAL: All Doors (so indicated on plans) shall be five-ply Golden Dowel Exterior doors made by Roddis Plywood Corporation, Marshfield, Wis. Doors shall be constructed utilizing the Roddis Time Conditioning process and covered by a Life-Time guarantee. All doors shall be identified with a golden colored dowel and the serial plate on the hinge side of door must be retained in place for inspection. All doors shall be treated with a wood preservative solution which seals the wood. No doors manufactured exceeding 4′ in width and 7′ in height unless installation approved by Roddis.

CORES: Cores shall be subjected to a special Roddis process and shall be made of low density* wood blocks no more than 2¼″ wide of varying lengths (none longer than 36″) assembled with the grain running parallel and vertically (from top to bottom of door). Cores shall be railed on two sides with matching edgestrips at least ½″ after trim. Double thickness strips top and bottom of any hardwood or softwood. Those on side edges to be same kind of wood as face veneer. The whole assembly shall be glued under pressure with water resistant resin glue and thoroughly kiln dried, seasoned and planed smooth.

CROSSBANDINGS: Crossbandings of 1/10″ thick, thoroughly dried, hardwood veneer shall be laid with the grain at right angles to that of the core and glued (pressure and heat) with waterproof phenolic resin glue to both sides of the core. Crossbandings shall run full to the four edges of the door.

FACE VENEERS: Only thoroughly dried, standard thickness face veneers** are to be used, laid with the grain at right angles to that of the crossbandings, and shall be glued (pressure and heat) with phenolic resin glue to both faces of the door and belt sanded smooth. This is not to be interpreted as meaning that the doors will be ready for painter's finish because grain may raise due to exposure to humidity and marks may result in handling.

Face veneers shall be as follows: **NOTE:** Here describe any special requirements of species, figure, pattern, inlays, etc. If more than one type is required, specify each separately and locate here or by reference to door schedules or special detail drawings.

Metal Door Bottoms and Glazing Strip:

All exterior doors shall be provided with 28-gauge aluminum moisture-protecting door bottoms (and glazing strip) in accordance with Roddis standard details. See page 4.

GLAZING: (Not by door manufacturer)—All glass for glazed doors shall be (specify).

Glazing shall be in accordance with details, using removable wood glazing molding set in white lead or varnish to seal against moisture absorption.

FITTING: Here specify factory sizing and fitting of doors and hardware.

Painting and Finishing:

Note: Here specify factory finishing (see page 15). Users who perform bleaching operations on Roddis doors, do so at their own risk.

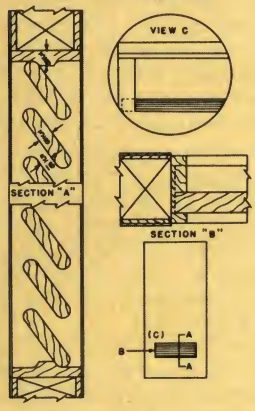
*Low density wood blocks are those weighing not more than 2300 pounds per 1000 board feet when kiln dried to a moisture content of 6%.

**Standard thickness of face veneers before sanding: Rotary Birch 1/26″, Plain Sliced Birch, Maple, Gum, Walnut, Rift Sliced Oak, Mahogany and most foreign woods 1/28″, Plain Sliced Red and White Oak 1/24″, White Pine 1/16″.

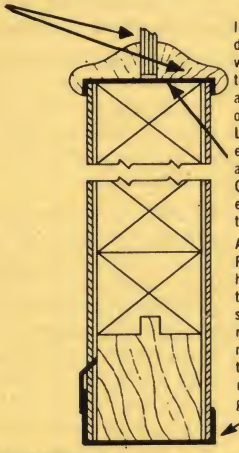
Roddis SOLID CORE DOOR

These drawings illustrate typical Roddis door details.
Through the years they have proved highly satisfactory.
Roddis also performs door detail work to architectural specifications.

Standard Louver Construction for flush doors (with round edge slats)



GLAZING CONTRACTOR SHOULD SET GLASS IN PUTTY AND EXTERIOR STOPS IN WHITE LEAD OR SPAR VARNISH.

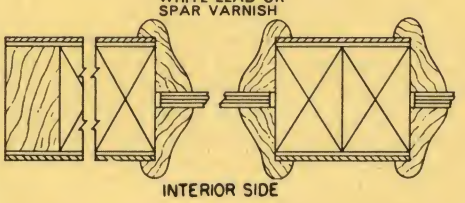


Inside of light opening and bottom of door thoroughly impregnated with wood preservative to seal wood prior to installing 28 gauge aluminum strips at the factory. Strip around bottom of door secured with aluminum nails. Lifetime guarantee on Golden Dowel exterior doors is effective only if aluminum flashing is employed. Quotations on Roddis Golden Dowel exterior doors automatically include this cost.

Aluminum moisture protection for Roddis Standard exterior doors is highly recommended and is installed at the factory for a nominal cost when specified. In cases where it is not felt necessary to use aluminum, doors must be sealed top and bottom at the time of installation and must be resealed as often as necessary or guarantee is voided.

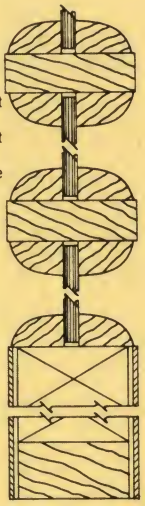
RECOMMENDED MOISTURE PROTECTION AND DIRT GUARD FOR EXTERIOR DOORS

EXTERIOR SIDE
STOPS SET IN WHITE LEAD OR SPAR VARNISH



INTERIOR SIDE

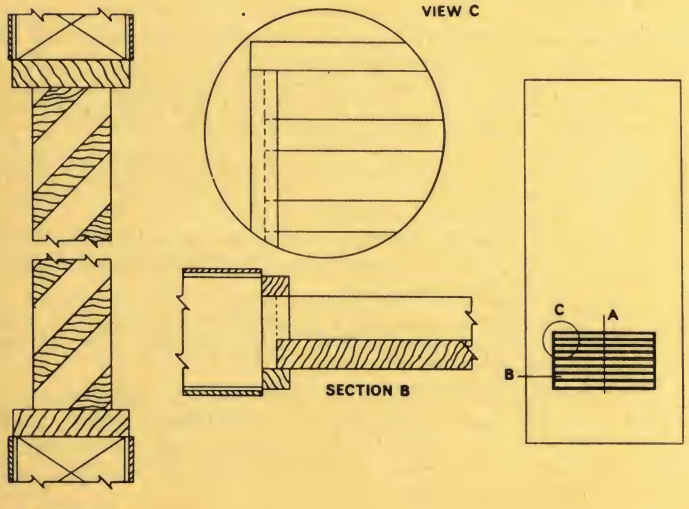
INDIVIDUAL LIGHT OPENINGS CUT OUT WHEN BARS ARE 1½" OR WIDER



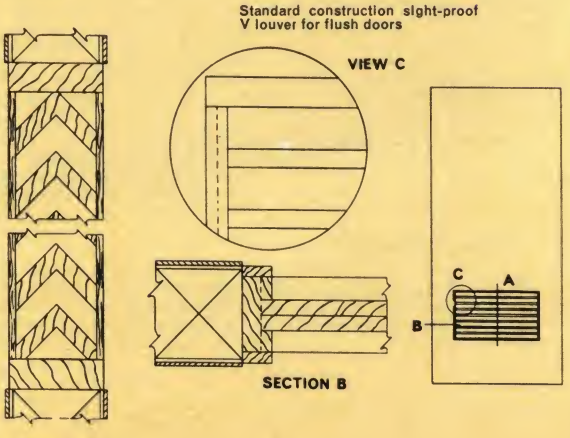
SOLID BARS USED WHEN MEASUREMENTS ARE LESS THAN 1½"

- Exterior applications—lip or rabbeted raised moldings are recommended.
- Interior applications—sunken bead molding is recommended.

STANDARD LOUVER CONSTRUCTION FOR FLUSH DOORS



Standard construction sight-proof V louver for flush doors



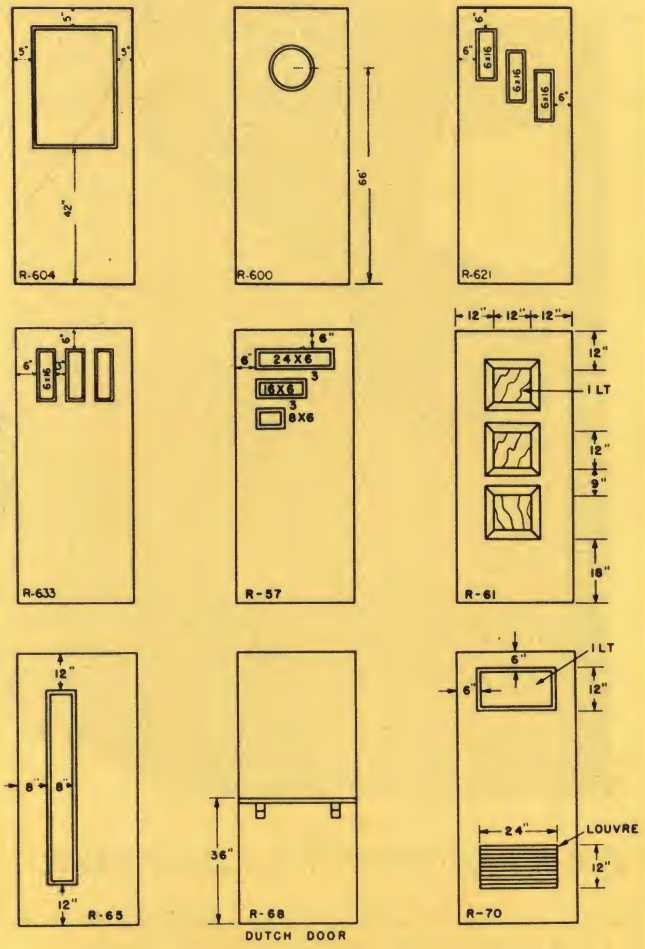
DETAILS HAVE PASSED THE TEST OF TIME

FACTORY-FINISHED DOORS—Roddis doors can be furnished primed and sealed or completely factory finished to architectural specification. (See page 15).

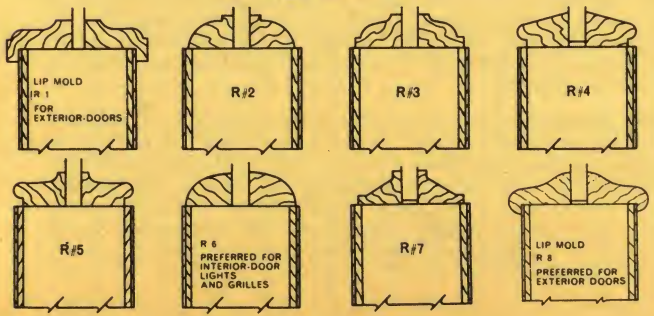
DETAIL WORK—Numerous door installations require light and louver openings and louver installation. Roddis is equipped to perform these detail operations to specification. Construction methods used are time tested. (See page 4).

MOISTURE PROTECTION—Roddis installs aluminum glazing strips at the bottom of light openings and at the bottom edges of the doors. Roddis recommends that when millwork firms install glazing, the lip mold on the exterior sides of the light openings be set in white lead or spar varnish, and the glass imbedded in putty. (See page 4).

REPRESENTATIVE LAYOUTS for FLUSH DOORS



Roddis stock door moldings. When ordering, specify by number



SPECIFICATIONS for Standard Solid Core Doors...Identified by the Red, White and Blue Dowel

GENERAL: All doors (so indicated on plans) shall be exterior five-ply Standard Flush Veneered doors made by Roddis Plywood Corp., Marshfield, Wisconsin. Doors shall be constructed in strict accordance with Roddis Standard Construction covered by their two-year Guarantee Bond (page 16) and permanently identified with the red-white-and-blue dowel. Doors shall be of sizes and thicknesses called for (1⅛″ to 2¼″ thick).

CORES: Cores shall be made of low density* wood blocks no more than 2¼″ wide of varying lengths none longer than 36″ assembled with the grain running parallel and vertically (from top to bottom of door). Cores shall be railed on two sides with matching strips at least ½″ after trim. Double thickness strips top and bottom of any hardwood or softwood. Those on side edges to be same kind of wood as face veneer. The whole assembly shall be glued under pressure with water-resistant resin glue and thoroughly kiln dried, seasoned and planed smooth.

CROSSBANDINGS: Crossbandings of 1/10″ thick, thoroughly dried, hardwood veneer shall be laid with the grain at right angles to that of the core and glued (pressure and heat) to both sides of the core. Crossbandings shall run full to the four edges of the door.

FACE VENEERS: Thoroughly dried, standard thickness face veneers** laid with the grain at right angles to that of the crossbandings, shall be glued (pressure and heat) with phenolic resin glue to both sides of the door and belt sanded smooth. This is not to be interpreted as meaning that the doors will be ready for painter's finish, because grain may raise due to exposure to humidity and marks may result from handling.

Face veneers ⅛″ and thicker are manufactured to customer specification at customer's risk. The Roddis Plywood Corp. will assume no responsibility for opening of joints or the checking of face veneers manufactured ⅛″ and thicker.

Face veneers shall be as follows: **NOTE:** Here describe any special requirements of species, figure, pattern, inlays, etc. If more than one type is required, specify each separately and locate here or by reference to door schedule or special detail drawings.

METAL DOOR BOTTOMS AND GLAZING STRIP: It is highly recommended that 28 gauge aluminum moisture-protecting door bottoms (and glazing strip) be specified on all exterior doors in accordance with Roddis standard details. (See page 4).

GLAZING: (Not by door manufacturer)—All glass for glazed doors shall be (specify).

Glazing shall be in accordance with details, using removable wood glazing molding set in white lead or varnish to seal against moisture absorption.

FITTING: Here specify factory sizing and fitting of doors and hardware.

PAINTING AND FINISHING: Note: Here specify factory finishing (See page 15). Users who perform bleaching operations on Roddis doors do so at their own risk.

*Low density wood blocks are those weighing not more than 2300 pounds per 1000 board feet when kiln dried to a moisture content of 6%.

**Standard thickness of face veneers before sanding: Rotary Birch 1/26″; Plain Sliced Birch, Maple, Gum, Walnut, Rift Sliced Oak, Mahogany and most foreign woods 1/28″; Plain Sliced Red and White Oak 1/24″; White Pine 1/16″.

Roddis

ANNOUNCES *the new* GOLDEN DOWEL B-LABEL, ONE-HOUR

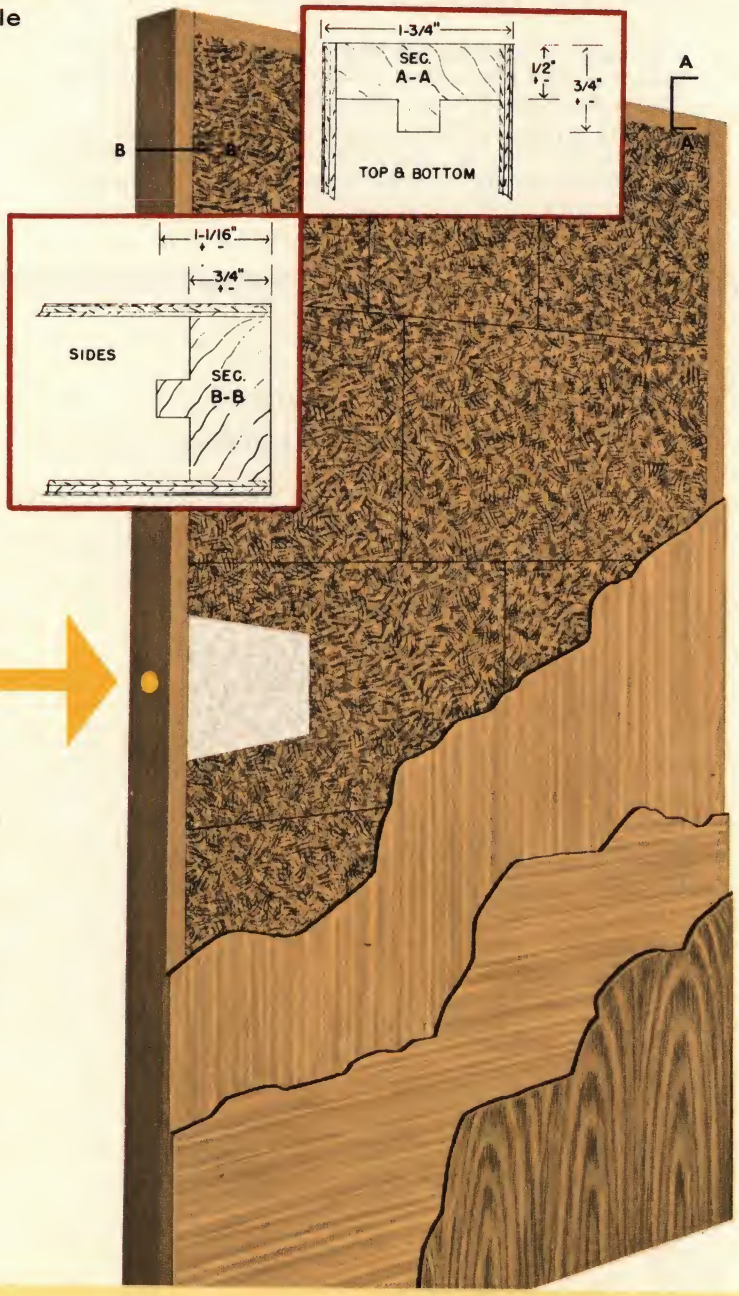
Patented core development now makes possible B-label and C-label fire doors with exceptional screw holding power... great sound resistance...added strength

CORE IS ALL WOOD

New Roddis Golden Dowel fire doors are all wood. Dimensioned wood particles are bonded with phenolic adhesive under pressure and heat. Equal strength in all directions and great sound resistance is obtained.

EXTRA WEIGHT GIVES ADDED STRENGTH

Weighing approximately six pounds per square foot, these new doors weigh about 50% more than mineral core fire doors. Added weight is one of the reasons for the outstanding sound resistance, fire resistance and good base for screw holding of Golden Dowel fire doors.



YOUR ASSURANCE OF PROTECTION

Roddis Golden Dowel B-label, one-hour fire doors are listed by Underwriters' Laboratories, Factory Mutual and the New York Board of Standards and Appeals (N.Y.B.S.&A., Calendar No. 165-54-SM). Roddis Golden Dowel C-label ¾ hour fire doors are also listed by Underwriters' Laboratories and the New York Board of Standards and Appeals (calendar number 354-58-SM)

EXCEPTIONAL SCREW HOLDING

The screw holding ability of these doors is exceptionally high. In comparison to mineral core fire doors, Roddis wood particle core doors have almost twice the screw holding ability.

SPECIFICATIONS: RODDIS GOLDEN DOWEL, B-LABEL

GENERAL: All doors required to maintain the integrity of One-Hour single door classification openings shall be seven ply Underwriters' Laboratories labeled fire doors manufactured by the Roddis Plywood Corporation, Marshfield, Wisconsin. The doors shall bear the label of Underwriters' Laboratories, Inc. Doors are intended for use in the protection of openings in **INTERIOR** walls of vertical shafts and corridor or room partitions. Door size shall not exceed 3'6" x 7'0" and the thickness shall not deviate from the approved thickness of 1¾".

Doors shall be covered by the Roddis Lifetime Guarantee (see page 2).

CORE: Core shall be composed of fire-proofed wood particles bonded with a waterproof thermo-setting resin into sectional slabs by heat and pressure. Core slab sections shall be tongue and grooved, bonded together, and railed with fire-proofed Birch lumber, ¾" thick on sides and ½" thick on the top and bottom edges. The rails shall be glued and joined to the core with a well fitting tongue and groove joint.

LOCK BLOCK: The lock block shall be composed of an asbestos compound and shall measure 9" in height where it joins the edgestrip, tapering to 8" in height. Width shall be 7¼". Unless otherwise specified, the standard height to the center of the lock block will be 36" for 80" doors and 38" for 84" doors. The center of the lock block shall be marked with ⅛" Golden Dowel.

FACE PANELS: Both sides of the door shall be faced with a three ply veneer panel. Panel faces shall be well dried, standard thickness* face veneers, laid with the grain perpendicular to that of the crossbanding. Both crossbanding (1/20" thick) and panel back (1/28" thick) shall be impregnated with fire-retardant chemicals. This three-ply panel shall extend the full width and length of the door.

FIRE DOOR...*and* C-LABEL ¾ HOUR DOOR

Guaranteed for the life of the installation

Roddis Golden Dowel Fire Doors have high screw-holding power.

***Comparative Screw Holding Properties**

With Face and Crossband

Standard Solid Core Doors (Softwood)	1,400 lbs.
Mineral Core Fire Doors	850 lbs.
Wood Particle Core Fire Doors	1,650 lbs.

Core Material Only

Pine Blocks	1,050 lbs.
Mineral Core	166 lbs.
Wood Particle Core	1,200 lbs.

*These tests were made with a #8 screw with one inch penetration. Pressure was then applied to determine pounds of resistance before the screw was withdrawn.

Golden Dowel C-Label, ¾ Hour Fire Doors with Light Openings up to 30″ x 40″... Another Roddis First

Now for the first time, architects have available *flush veneered C-label fire doors* . . . thanks to the forward door research program at Roddis.

Important cost savings can be yours with this new door development, for in many applications, the new Roddis C-label fire door can be used instead of more costly B-label fire doors.

SPECIFICATIONS:

Roddis Golden Dowel, C-Label, ¾ Hour Fire Retardant Doors

Specifications are identical to those listed below on Roddis Golden Dowel, B-label fire doors with the exception of glazing, type of fire retardant treatment given wood particles, and the fact that the C-label is a one-piece core and is five-ply construction utilizing a 1/10″ fire-retardant treated crossbanding.

GLAZING: Approved for vision panels up to 1,200 sq. inches. Factory will cut opening and supply complete vision panel assembly (standard sizes 30″ x 40″, 30″ x 36″, 24″ x 36″, 18″ x 30″, 8″ x 12″, 10″ x 10″) with or without ¼″ wire glass. A minimum of 5″ top and 5″ sides should be left when cutting door for light openings.

ONE-HOUR FIRE RETARDANT DOORS

A. Face veneers shall be as follows:

NOTE: Here describe any special requirements of species, figure, pattern, etc. If more than one type is required, specify each separately and locate here, or by reference to door schedules or special detail drawings.

ADHESIVES: The core and rails shall be bonded together with thermosetting waterproof adhesive. The three-ply face panels shall be bonded together with waterproof adhesive and bonded to the core with waterproof adhesive.

SANDING: Both door faces shall be thoroughly belt sanded to a smooth even texture. This is not to be interpreted as meaning that the doors will be ready for painter's finish, because grain may raise due to exposure to humidity and marks may result from handling.

GLAZING: (Approval Pending)

FITTING: Trim top, bottom and side edges equally when fitting this door so that structural strength of door will not be impaired. Do not expose the core at any point. Roddis Plywood Corporation will not recognize claims arising from failure to comply with these instructions.

PAINTING AND FINISHING: Here specify factory finishing. (See page 15). Users who perform bleaching operations do so at their own risk.

NOTICE—The lumber used on the four edges of one-hour fire doors has been impregnated with a hygroscopic fireproofing salt. It is absolutely necessary to finish all four edges, as soon as possible to seal these salts in the wood to avoid staining and wood deterioration.

*STANDARD THICKNESS FACE VENEERS—Standard thickness of face veneers before sanding: Rotary Birch 1/26″; Plain Sliced Birch, Maple, Gum, Walnut, Rift Sliced Oak, Mahogany and most foreign woods 1/28″; Plain Sliced Red and White Oak 1/24″; White Pine 1/16″.

Roddis MINERAL CORE

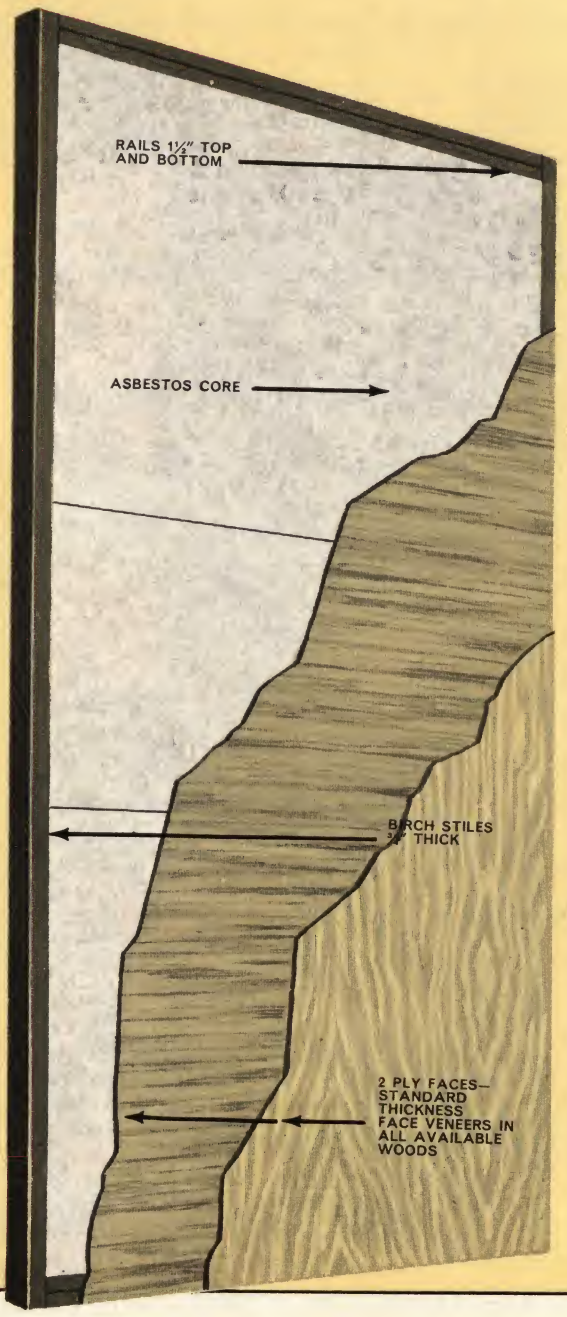
LIGHTWEIGHT...WARP FREE...LOW SOUND TRANSMISSION

Safety features that guard life and property are built into Roddis Mineral Core wood-faced fire doors, labeled by the Underwriters' Laboratories for use in B and C openings.

For effective fire protection, Roddis B-label fire doors are used in many institutions, including hospitals, schools and business establishments for stairway and room entrances, dumb waiter and fire escape openings. For residences, there's a growing trend to use these doors for bedrooms, basements and for entrances where a garage is connected directly to the house.

Produced in all available wood species, Roddis fire doors permit architects and builders to match their fire doors with conventional Roddis flush doors in a building.

Manufactured in all standard sizes, Roddis Mineral Core fire doors are available in widths up to 4 feet and heights to 7 feet.


RAILS 1½" TOP AND BOTTOM
ASBESTOS CORE
BIRCH STILES ¾" THICK
2 PLY FACES—STANDARD THICKNESS FACE VENEERS IN ALL AVAILABLE WOODS

CONSTRUCTION FEATURES

The core is made of a special asbestos compound that is non-combustible. The door is faced on both sides with beautifully matched veneers and the sides and top are banded with fire-proofed lumber. To assure stability, the special asbestos core is made up with sections assembled together with tight tongue-and-groove joints.

Other outstanding features include: It is lightweight, weighing approximately the same as conventional solid core doors. Also the door is warp-free, and has a low sound transmission factor.

SPECIFICATIONS: MINERAL CORE, ONE-HOUR, B-LABEL

1. GENERAL: All doors required to maintain the integrity of B and lower single door openings, shall be five ply Underwriters' Laboratories B-label fire doors manufactured by the Roddis Plywood Corporation, Marshfield, Wisconsin, and labeled accordingly.

A. Doors shall be covered by the Roddis Lifetime Guarantee. (See page 2.)

B. Doors are intended for use in the protection of openings in *interior* walls of vertical shafts and corridor or room partitions.

C. The size shall not exceed 4'0" x 7'0", and the thickness shall not deviate from the approved thickness of 1¾".

2. CORE: The core shall consist of well-balanced sections of a rigid, incombustible inorganic bonded, long-fibered asbestos panel having an approximate density of 23 pounds per cubic foot. The sections shall be joined tightly together with a well-fitting tongue and groove joint, and the assembly shall be railed with Roddis fireproofed Birch lumber, ¾" thick on the sides, and 1½" thick on the top and bottom edges. The rails shall be glued and joined to the core assembly with a well-fitting tongue-and-groove joint.

3. FACE PANELS: The core assembly shall be faced on each side with face veneers and cross banding ⅛" in thickness. The face shall be well dried, standard thickness veneers—laid with the grain perpendicular to that of the crossbanding. The face and crossbanding veneers of each panel shall extend the full width and length of the door.

A. Face veneers shall be as follows:

NOTE: Here describe any special requirements of species, figure, pattern, etc. If more than one type is required, specify each separately and locate here, or by reference to door schedules or special detail drawings.

4. ADHESIVES: The core and rails shall be bonded together with resorcinol waterproof adhesive. The entire core assembly shall be

B-LABEL, ONE-HOUR FIRE DOOR

Guaranteed for the life of the installation

OUTSTANDING FEATURES

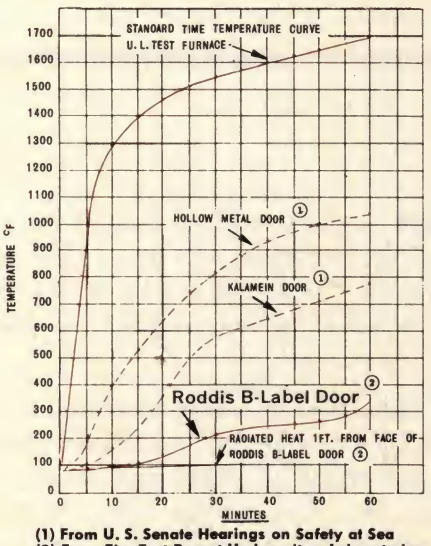
- Non-combustible core of special asbestos compound.
- Produced in all available wood species.
- Available in widths up to 4 feet . . . heights up to 7 feet.
- Warp-free, low sound transmission.
- Completely stable core. Sections are assembled with tight tongue-and-groove joints.

UNDERWRITERS' LABORATORIES LABELED . . .

And approved by Factory Mutual and The New York Board of Standards and Appeals (N.Y.B.S. & A., Calander No. 166-54-SA).

This metal Underwriters' Laboratories label is fastened to every Roddis One-Hour, B-label Fire Door.

HEAT TRANSMISSION COMPARISON



(1) From U. S. Senate Hearings on Safety at Sea
(2) From Fire Test Report Underwriters Laboratories

Confining fire is only one function of a fire door. The other is to retard the transmission of heat through the door, eliminating the possibility of igniting combustible materials contacting its other side. Dry paper will ignite when placed against a surface with a temperature approaching 500° F.

As shown in the graph, even though one side of the Roddis Mineral Core fire door was subjected to temperatures of 1700° F. in this sixty-minute test, the maximum radiated temperature, measured one foot from the opposite side, was only slightly over 100° F. The surface temperature of this side measured only about 350° F.

FIRE RETARDANT DOORS

sized on two sides to assure a perfect bond of the face panels to the core. The face panels shall be assembled to the core with waterproof adhesive and maintained under adequate pressure until completely cured.

5. SANDING: Both door faces shall be thoroughly belt sanded to a smooth, even texture. This is not to be interpreted as meaning that the doors will be ready for painter's finish, because grain may raise due to exposure to humidity and marks may result from handling.

6. GLAZING: Vision Panel Frames available for door sizes up to 4'0" in width and up to 7'0" in height. Factory will cut opening and supply complete vision panel assembly (standard sizes 8" x 12" and 10" x 10") with or without ¼" wire glass.

7. FITTING: Trim top, bottom and side edges equally when fitting this door so that structural strength of door will not be impaired. Do not expose the core at any point. Roddis Plywood Corporation will not recognize claims arising from failure to comply with these instructions.

8. PAINTING AND FINISHING: Here specify factory finishing. (See page 15.) Users who perform bleaching operations do so at their own risk.

NOTICE—The lumber used on the four edges of B-label fire doors has been impregnated with a hygroscopic fireproofing salt. It is absolutely necessary to finish all four edges as soon as possible to seal these salts in the wood to avoid staining and wood deterioration.

**STANDARD THICKNESS FACE VENEERS—Standard thickness of face veneers before sanding: Rotary Birch 1/26"; Plain Sliced Birch, Maple, Gum, Walnut, Rift Sliced Oak, Mahogany and most foreign woods 1/28"; Plain Sliced Red and White Oak 1/24"; White Pine 1/16".

Roddis INSTALLATION AND HARDWARE

the Underwriters' Laboratories specify that Roddis B-label fire doors used for vertical shaft and corridor openings be hung and equipped as follows:

THE LABEL is placed one-third down from the top of the door on the hinge side in manufacture. The label should be at the top when the door is installed. This label is not to be removed for any reason.

CLEARANCE. The maximum clearance shall be 1/16″ at the top and sides and 3/16″ at the bottom. To obtain proper width clearance and bevel, plane the lock edge only. The labeled edge is not to be trimmed or beveled. Trim equal amounts off both top and bottom to obtain proper height clearance. (See page 9—Painting and Finishing.)

HINGES. Fasten the door leaves of full-mortise and half-mortise hinges to the door with 1¼″ No. 12 flat head Type A sheet metal screws. The door leaf of full-surface and half-surface hinges should be bolted through the door as illustrated.

The Underwriters' Laboratories specify that hinges for Class B, C, D and E doors shall be full-mortise, half-mortise, half-surface, or full-surface. These are to be made of steel and not less than 4½″ in height and 0.134 in. in thickness. Also, olive knuckle steel hinges not less than 6 in. in height and 0.225 in. in thickness may be used. Two hinges shall be provided for doors up to and including 60 in. in height, and an additional hinge for each 30 in., or fraction thereof in height.

Doors not exceeding 5 ft. in height and 3 ft. in width shall be provided with two hinges of the types and sizes, as specified above, or not less than 4″ in height and 0.130 in. in thickness.

LOCKS. The Underwriters' Laboratories require that single-swing doors for Class B, C, D, and E openings be equipped with an Underwriters' Laboratories listed, single point lock having a minimum throw of ½″. Either the tubular or mortise-type lock set may be used. The locks should be installed according to manufacturer's instructions. Those locks having screwless roses are recommended.

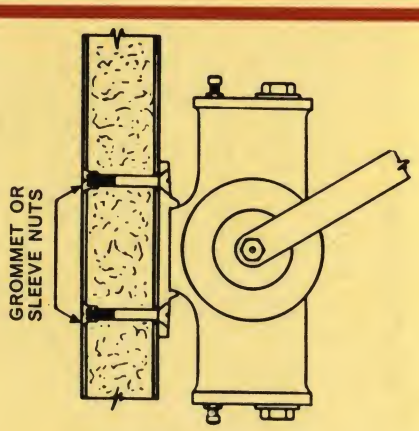
A positive latch must be used as the air currents created by a fire may cause the door to stand open, adding to the draft and losing the protection the door affords. Consequently, doors equipped with pull only are not suitable.

DOOR CLOSERS. The Underwriters' Laboratories have listed only the overhead, face-mounted and semi-concealed door closers. Those equipped with hold-open mechanisms are required to have a fusible link release incorporated in them.

FRAMES. The Roddis B-label Fire Door should always be installed in Underwriters' Laboratories labeled steel frames—16 gauge for openings of 3′6″ and under, and 14 gauge for openings over 3′6″. (For a list of suppliers of Underwriters' Laboratories listed hardware for use with Roddis B-label fire doors, write for FIRE PROTECTION EQUIPMENT LIST, published by Underwriters' Laboratories, Inc., 161 E. Sixth Ave., New York 13, N.Y.)

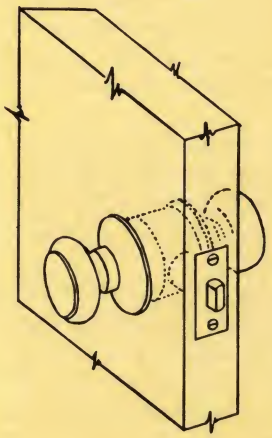
RECOMMENDATIONS FOR B-LABEL, COMPOSITE CORE, ONE-HOUR FIRE DOORS

preferred methods of installing tubular lock, half-surface hinge, door check mounting and full mortise hinge in Roddis B-label fire doors.

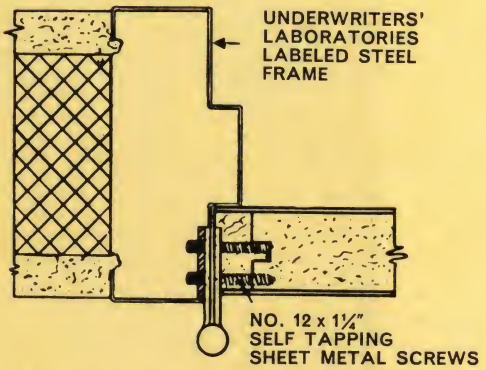


DOOR CHECKS WITH
HOLD-OPEN ARM
MUST BE EQUIPPED WITH
A FUSIBLE LINK RELEASE

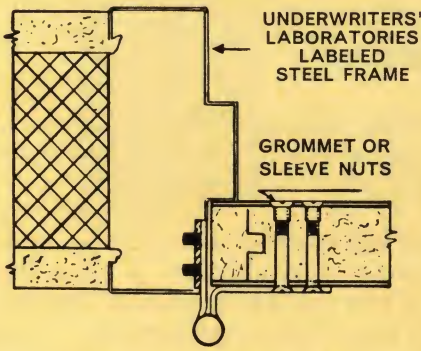
DOOR CHECK MOUNTING



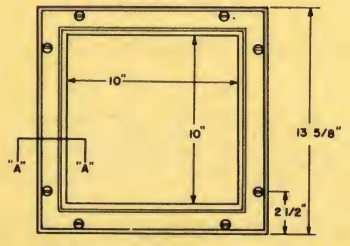
TUBULAR LOCKSET



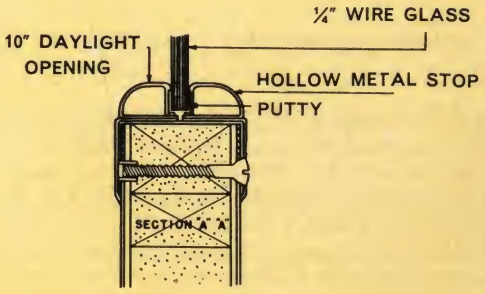
FULL MORTISE HINGE



HALF SURFACE HINGE

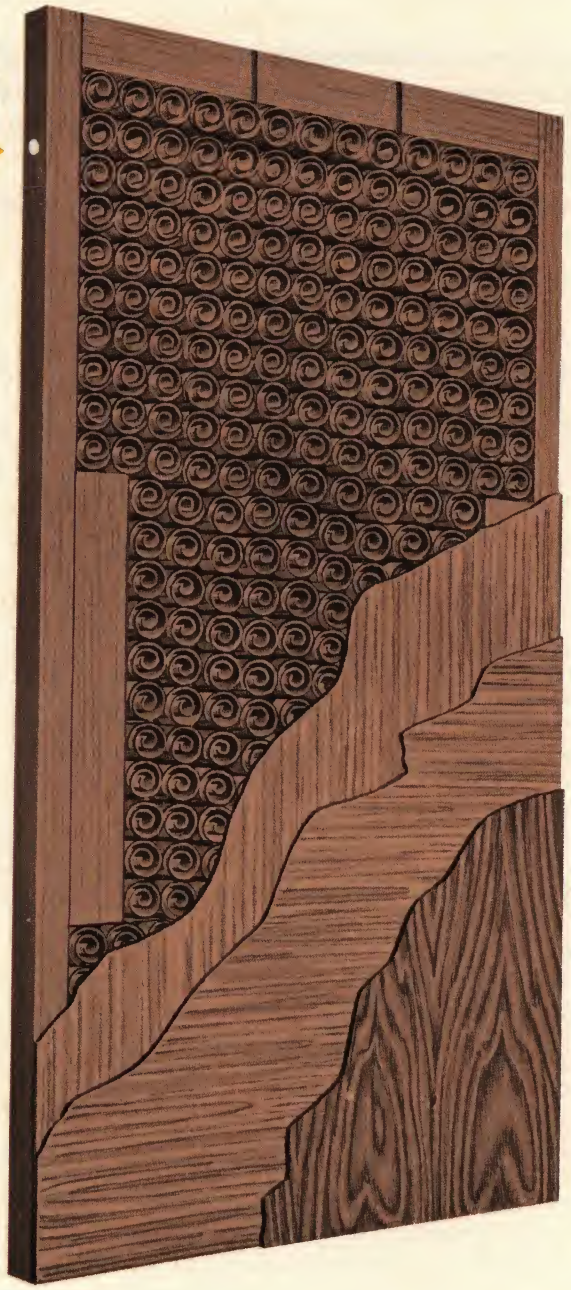


RODDIS VISION PANEL METAL FRAME
(STANDARD SIZE 10" x 10" AND 8" x 12")



Roddis HOUSEMART HOLLOW CORE DOORS...

The new Roddis 7-Ply
HOUSEMART HOLLOW CORE DOOR
Unique Wood Spiral Core utilized for maximum stability and dependability



The new Roddis seven-ply Housemart hollow core door presents practical economy and exceptional flexibility of installation. It is the ideal answer for strength, service and beauty on a limited budget. Here are a few of the features of this new Roddis door.

- **WOOD-SPIRAL CORE**—Maximum surface area for the adhesion of door faces is obtained with precision-cut wood spirals. All spirals touch one another giving superior face support.
- **SEVEN-PLY CONSTRUCTION**—Added quality is built into the new Housemart with time-proven, seven-ply construction.
- **STRONG**—Great strength has been built into this new door without adding weight . . . doors are easy to install.
- **GUARANTEED**—The new Housemart is backed by the Roddis Two-Year Guarantee Bond . . . your assurance of satisfactory service. (See page 16 for guarantee details.)
- **VERSATILE**—Standard door sizes in 1⅜″ and 1¾″ thickness as well as specified sizes are manufactured in all available woods.

FOR YOUR NEXT JOB where minimum cost coupled with maximum dependability is of primary importance, it will pay you to specify the new Roddis Housemart door. It is a quality door . . . made by a company that for over sixty years has produced fine wood products of superior craftsmanship.

Complete specifications are listed below

SPECIFICATIONS . . . Roddis Seven-Ply Housemart Hollow Core Doors

All doors (as indicated on plans) shall be seven-ply Housemart hollow core doors, made by the Roddis Plywood Corporation, Marshfield, Wisconsin, and covered by the Roddis Two-Year Guarantee Bond (See page 16). Doors shall be identified with a black-white-black dowel.

Cores shall be composed of wood spirals cut from prime lumber placed tangent to one another, and face panels shall be 3-ply construction utilizing standard thickness face veneers.

Lock blocks shall be on both sides of doors 4 1/16″ wide (including stiles) x 24″ on 6′8″ and 7′0″ doors. Top and bottom rails shall be 2⅝″ wide with vertical softwood edge strips 1 3/16″ wide.

Where hardwood edge strips are specified, they shall be ½″ thick, with backup strip attached, to make a total stile width of 1 3/16″. Doors shall be bonded with a water-resistant adhesive unless otherwise specified.

THE INSTITUTIONAL...

THE RODDIS INSTITUTIONAL DOOR is completely reversible, having identical construction top and bottom. The door is constructed to be easily fitted with special hardware, closers, kick plates and panic bars. Laminated hardwood stiles give added stability.

RODDIS INSTITUTIONAL—IDENTIFIED BY BLACK DOWEL. PRECISION-CUT WOOD SPIRALS ALL TOUCHING ONE ANOTHER GIVE EXCELLENT SUPPORT TO FACE PANELS.

SPECIFICATIONS...

Roddis Institutional Doors

All doors (so indicated on plans) shall be seven-ply, 1¾″ thick institutional doors made by the Roddis Plywood Corp., Marshfield, Wisconsin, and covered by the Roddis Two-Year Guarantee Bond (See page 16). Doors shall be identified with a black dowel.

Cores shall be composed of wood spirals cut from prime lumber placed tangent to one another. Top and bottom rails shall be softwood lumber 10⅜″ wide.

Vertical edge strips shall be pine (unless otherwise specified) ½″ wide after factory trim. Combined with laminated hardwood stile, overall width of side assembly shall be 2½″.

Lock blocks shall be of softwood on both sides of the door, 5½″ wide and 21″ from each end of the door. Center cross rail shall be 3″ wide.

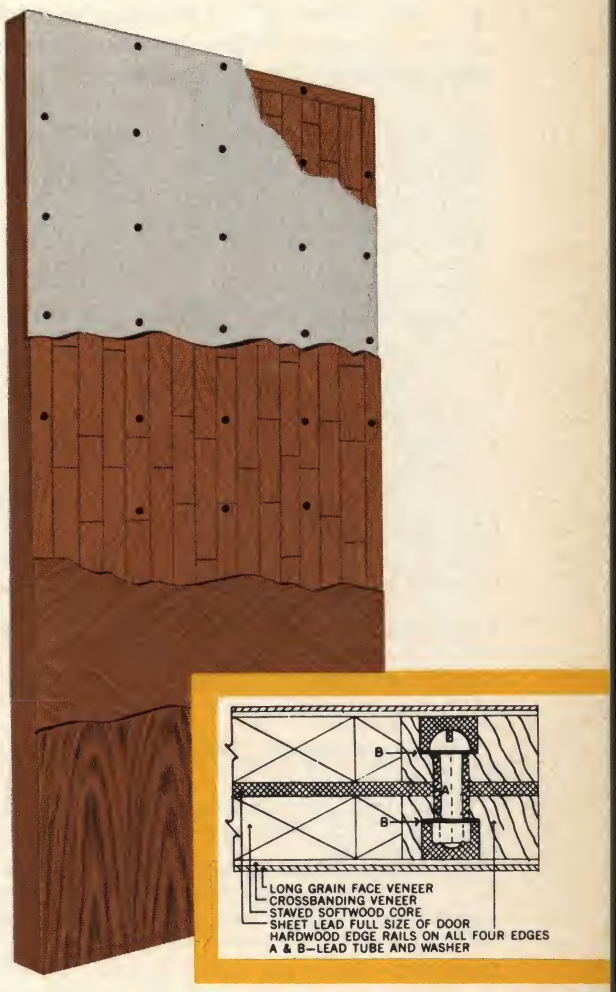
Note: If specifications call for cross rail to be located off center, dowel will indicate top of door.

Face panels shall be 3 ply construction utilizing standard thickness face veneers. Doors shall be completely assembled with water resistant adhesive unless otherwise specified.

All doors to be used in exterior locations shall be provided with 28 gauge aluminum bottoms and glazing strip in accordance with Roddis standard details. (This protection is applied by the Roddis Plywood Corporation at slight additional cost only if specified.)

AND X-RAY DOORS

RODDIS X-RAY DOORS are designed for beauty with complete protection. They are equipped with a continuous sheet of lead set midway between a divided wood core. Doors available in 1¾″ to 3″ thickness and lead thickness of 1/32″ to ½″.



SPECIFICATIONS...

Roddis X-Ray Doors

Doors, (so indicated on plans) shall be Roddis X-ray doors manufactured by Roddis Plywood Corporation, Marshfield, Wisconsin.

Divided wood cores composed of low density blocks bonded together with water resistant resin glue and banded four sides with hardwood lumber shall house a continuous sheet of lead running full to the four edges of the door. Side rails shall be 1½″ and top and bottom rails 4″. This assembly shall be secured with lead covered bolts spaced 8″ on center for 6′8″ doors and 9⅛″ on center for 7′0″ doors. To facilitate the fastening of hinges or door closers, there shall be no bolts in areas 3″ x 7¾″ on the four corners of the door, and there will also be a space free of bolts on both edges of the door for center hinges. 1/10″ hardwood crossbandings and standard thickness face veneers shall be bonded to the core with phenolic resin glue and the doors belt sanded smooth.

Vertical edge strips shall be of same species as face veneers. Lead thickness shall be as indicated on plans. (1/32″ or thicker.)

Roddis

GOLDEN DOWEL SOUNDPROOF DOORS

Guaranteed for the Life of the Installation

Three Thicknesses offered... 1¾", 2¼" and 3"...having average sound transmission loss ratings of 38, 42 and 44 decibels.

For offices, schools, hospitals and plants . . . in any application where sound must be controlled, new RODDIS GOLDEN DOWEL SOUNDPROOF DOORS are highly recommended. These doors utilize the New Roddis high-density wood particle core which gives maximum stability plus required acoustical properties.

TABLE OF SOUND TRANSMISSION LOSS RATINGS

Tests conducted according to ASTM Standard E90-55
(Copies of actual test results available on request)

RODDIS SOUND-PROOF DOORS	DECIBEL RATING CYCLES/SECOND									
	125	177	250	354	500	707	1000	2000	4000	Average
3" Thickness	43	47	39	43	42	41	42	48	53	44
2¼" Thickness	39	46	32	40	40	41	40	47	51	42
1¾" Thickness	36	44	33	36	33	33	38	43	49	38

DOOR WEIGHTS—The 3" thick soundproof door is 13 lbs. per sq. ft.—2¼" is 12 lbs.—1¾" is 6½ lbs.

HINGES AND LOCKS—Use three hinges, size 4½ x 4½ for doors 1¾" up to 3'0" x 7'0". Use 5 x 4½ hinges for larger doors in same thickness.

For 2¼" doors, use three hinges, size 5 x 5 for doors up to 3'0" x 7'0". For larger doors in same thickness use 6 x 5 hinges.

For 3" doors, use three hinges, size 6 x 6 for doors up to 3'0" x 7'0". For larger doors in same thickness use four hinges, size 6 x 6.

Type hinges for all doors should be extra heavy, ball bearing.

Use any conventional locks—cylindrical preferred.

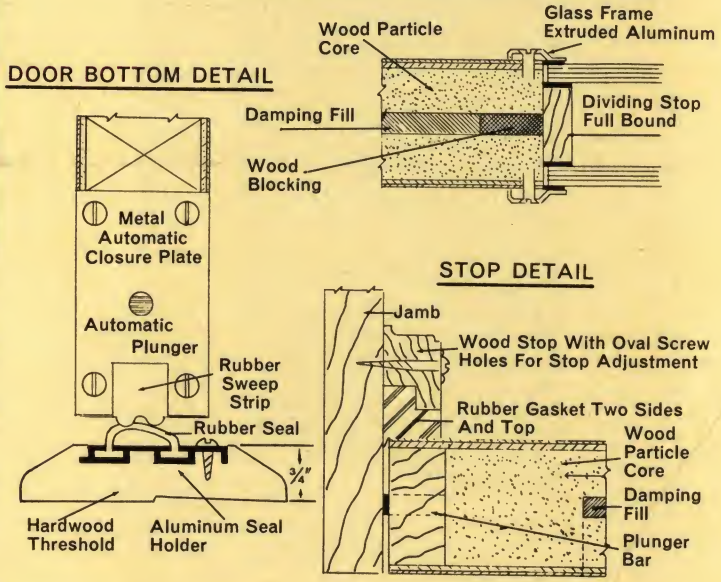
SIZES—For all three thickness doors, the maximum size is 48" x 96" and the minimum size is 12" x 48".

SEALING—Doors are sealed around top and sides with gasketed stops. These stops are applied with adjustable screws and washers after door is hung. For a 3' x 7' or larger door, the screws should be no more than 8" apart. Smaller doors may have a screw spacing up to 12" apart.

Bottom of the doors are sealed with a seal and also a threshold seal. Threshold should be bonded to the floor with calking compound, even though nailed. The stop adjustment is very important. Gasketed stops should be just tight enough to make a positive contact all around the door but must not bind it. The threshold closure is adjusted with a rod. Adjustments are made by screwing the rod out or in until the rubber is pressed down firmly against threshold gasket.

LIGHT DETAIL

MAXIMUM OPENING 20"x20" WITH FRAME CUT AND MITERED READY FOR INSTALLATION.



Center Of 2¼" And 3" Doors Has ¼" Thickness Damping Fill Extending To Within A Minimum 3½" Of Outside Edges And 3" Of Top And Bottom Edges. Damping Fill Not Utilized In 1¾" Doors.

COMBINED SPECIFICATIONS...Roddis Golden Dowel Soundproof Flush Veneered Doors...1¾", 2¼" and 3"

All sound insulating doors (so indicated on plans) shall be five-ply, wood particle core doors manufactured by the Roddis Plywood Corporation, Marshfield, Wisconsin, to provide a sound reduction of (give rating) decibels. Doors shall be of the construction tested and in compliance with ASTM standard E90-55.

All doors shall be identified with a tri-colored dowel (blue, gold, blue) and shall be covered by a life-time guarantee. The serial plate on the hinge side of the doors must be retained in place for inspection.

Doors shall have flush, unbroken surfaces on both sides and wood particle core shall be railed on two sides with edgestrips same specie wood as face veneer at least ½" after trim. Top edge shall have double thickness edgestrips of any hardwood or softwood, and bottom edge a 3" edgestrip, machined for bottom seal.

Crossbanding shall be 1/10" thick hardwood veneer, and standard thickness face veneers shall be utilized. Waterproof adhesive shall be used to bond faces, crossbands and edges assemblies.

Both 2¼" and 3" thickness doors shall have core center filled with special damping material ¼" in thickness and extending to within a minimum 3½" from side edges and 3" from top and bottom edges. The 1¾" thickness door shall not utilize a damping material but shall have a slotted core with two slots ⅛" wide and ¾" deep spaced on one side, and one slot of the same dimensions on the opposite side.

Doors shall be furnished complete with stops, gaskets and threshold sealing components.

GLAZING—Not by door manufacturer. Roddis will supply extruded aluminum frames up to 20" x 20", cut to size and mitred, ready for installation. Light opening must be specified when door is manufactured so that necessary blocking can be made. Light openings cannot be cut in doors not having blocking or damping fill will be lost.

Finishing—Here specify factory finishing (See Page 15).

NOW...FACTORY PRIME AND SEAL PROTECTION...*or* COMPLETE FINISHING OF DOORS OFFERED

Architects are quickly seeing the important cost-savings and numerous other advantages in having Roddis prefinish doors for them.

RODDIS PRIME AND SEAL locks in wood beauty; shuts out dirt, disfiguring stains and troublesome moisture during transportation and storage. Final finishing of doors on the job is made practically foolproof.

This Roddis process can reduce finishing costs substantially because it does away with all preparatory finishing steps. With Roddis Prime and Seal, the only work required is the application of the final finish. As many as five time consuming and costly steps are eliminated.

Exterior or interior finishes can be applied to Roddis Prime and Seal doors. In addition, any good oil or alcohol soluble stain may be used for coloring.

RODDIS COMPLETE FINISHING saves time on the job and can be done at the factory at less cost. Roddis finishes are used (unless others are specified). They give maximum wear, have high chemical and scratch resistance and do not yellow with age.

Doors are individually paper wrapped for protection in shipment and handling.

WHAT A DIFFERENCE RODDIS PRIME AND SEAL MAKES! Raw unprotected door at left shows smudges and scuffs so often inflicted during transportation and handling by tradesmen. Door at right, RODDIS PRIMED AND SEALED is unmarred, clean, dry and perfect for final finishing. This Roddis process is also an excellent protection against blue stain which frequently occurs on oak doors.

SPECIFICATIONS... Roddis Primed and Sealed Doors

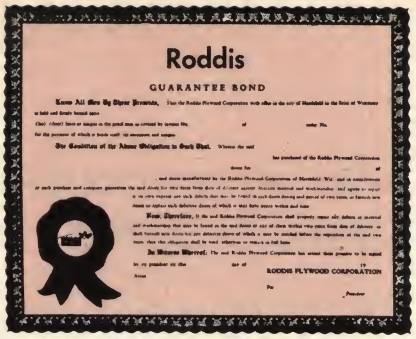
Door faces shall be primed and sealed by the Roddis Plywood Corporation, Marshfield, Wisconsin, utilizing a Roddis synthetic sealer in combination with a series of sanding, polishing operations and inspections. Doors so processed shall be ready for final finish coat.

SPECIFICATIONS... Roddis Completely Finished Doors

Door faces shall be completely finished and the four edges sealed by the Roddis Plywood Corporation, Marshfield, Wisconsin, utilizing Roddis finishes (unless others are specified). Doors shall be sealed, filled (if required), and stained (to specified color) with the doors properly sanded and polished to give a smooth base for two cover coats of Roddis Semi-gloss clear finish. Doors shall be individually paper wrapped prior to shipment.

NOTE: Conveniently packed Roddis finishes are recommended to finish edges on the job.

Roddis standard doors carry this Two-Year Guarantee Bond.
For details of Lifetime Guarantee, see page 2.


Roddis

GUARANTEE BOND

STANDARD RODDIS DOOR GUARANTEE

The Standard Door Guarantee of the National Woodwork Manufacturers Association listed below is the basis for Roddis two-year guarantee. While the NWMA guarantee covers one year, the Roddis guarantee covers a two-year period. The Roddis Plywood Corporation is a member of this organization.

All doors produced by members of the National Woodwork Manufacturers Association, Inc., are guaranteed by the manufacturer for one year from date of shipment by the manufacturer to be of good material and workmanship, free from defects which render them unserviceable or unfit for the use for which they were manufactured. Natural variations in the color or texture of the wood are not to be considered as defects.

Doors must be accorded reasonable treatment by the purchaser. Doors must be stored or hung in dry buildings and never in damp, moist or freshly plastered areas. Doors must not be subjected to abnormal heat, dryness or humidity. The utility or structural strength of the door must not be impaired in the fitting of the door, the application of hardware, or cutting and altering the door for lights, louvers, panels and any other special details. When solid core and hollow core flush doors are cut for lights or louvers, the portion between the cut out area and the edge of the door shall not be less than 5 inches wide at any point; and the cut out area shall not exceed 40% of the area of the face of the door; and in addition the cut out area of a hollow core door shall not exceed half the height of the door and shall be suitably prepared. *Immediately after fitting, the entire door including top and bottom edges must receive two coats of paint, varnish or sealer* to prevent undue absorption of moisture. The manufacturer will not assume responsibility for doors which become defective because of failure to follow these recommendations or for hazards of shipment or storage after the doors leave the control of the manufacturer.

Doors must be inspected upon arrival for visible defects and all claims or complaints based thereon must be filed immediately and before the doors are hung and before the first coat of painter's finish is applied.

The manufacturer agrees to repair or replace in the white, unfitted, and without charge, any door found to be defective within the meaning of this guarantee.

Doors must not be repaired or replaced without first obtaining the consent of the manufacturer.

A warp or twist of not to exceed ¼ inch shall not be considered a defect.

INTERPRETATION OF WARP OR TWIST

"A warp or twist of not to exceed ¼ inch shall not be considered a defect." This refers to any distortion in the door itself and not its relationship to the frame or jamb in which it is hung. Therefore, a warp or twist exceeding ¼ inch shall be considered a defect only:

1. When warp is determined by applying a straight edge to the concave face of the door, or
2. When twist is determined by placing the face of the door against a true plane surface. A simple device to determine and measure "twist" may be made by placing two cross-members on a post, one about door height and the other slightly above the floor. The cross-members must be perfectly straight, and true and plumbed into perfect alignment.

The guarantee against warp or twist does not apply to the following:

A. 1⅛″ and 1⅜″ thick doors that are wider than 3′0″ or higher than 7′0″.
B. Doors with face veneers of different species.
C. Doors that are improperly hung or do not swing freely.

Roddis

PLYWOOD CORPORATION
MARSHFIELD, WISCONSIN

R.P.C. 128-60-80M

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